

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:** Casey, William**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-028082**Date Inspected:** 01-Aug-2012**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1930**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Job Site**CWI Name:** See below.**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

Quality Assurance Inspector (QA) Fritz Belford was at the American Bridge/Fluor (ABF) job site at Yerba Buena Island in California between the times noted above in order to monitor Quality Control functions and the in process work being performed by ABF personnel. The following items were observed:

OBG

This QA observed the following internally of OBG 12W at various locations:

Authorized welder Jin Pei Wang #7299 was observed welding on weld 12W W2.1-A1 (4G) at Y location 17000 and 15000 utilizing Caltrans approved Welding Procedure Specification's (WPS) ABF-WPS-D15-3110-4 for Flux Core Arc Welding. Welder Pei was also observed grinding to remove the indication at Y location 12650. The indication was removed at 11mm deep in a 65mm x 55mm area. The indication area was Magnetic Particle Inspected (MT) by this QA Inspector following QC Chris Conche (MT) inspection and no indication was noted.

Authorized welder Mike Jimenez #4671 was observed continuing on from the previous day with welding weld number 12W PP111.1- LS2 and LS3(3G) on the deck longitudinal stiffeners utilizing Caltrans approved Welding Procedure Specification's (WPS) ABF-WPS-D15-1032-3.

Authorized welder Chris Bruce #8901 was observed welding on weld 12W W2.1 PP115.5-BW2 (3G) for panel point web complete joint penetration weld utilizing Caltrans approved Welding Procedure Specification's (WPS) ABF-WPS-D15-1040.

Authorized welder Chang Qiu Chen #2212 was observed welding on weld 12W W2.1 PP116.5-BW2 (3G) for panel point web complete joint penetration weld utilizing Caltrans approved Welding Procedure Specification's (WPS) ABF-WPS-D15-1040.

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Also noted was QC Chris Conche checking welding parameters for welders Chris Bruce #8901 and Changgiu Chan # 2312.

This QA advised QA Lead Danny Reyes of root opening issues with welds 12W W2.1 PP116.5-BW2 and 12W W2.1 PP115.5-BW2 under the current Welding Procedure Specifications (WPS) ABF-WPS-D15-1030-1. QA Lead Danny Reyes later advised this QA that the matter was known to QC and had been resolved with the Welding Procedure Specifications (WPS) ABF-WPS-D15-1040. After review of the alternate WPS (ABF-WPS-D15-1040), fewer areas on the welds needed “buttering” for excessive root opening. Some of the weld root openings in OBG 12W, in way of the Panel Point webs will need to be addressed prior to commencing of any welds. The root opening issue was also discussed with QC Chris Conche.

The internal side of weld 12W W2.1-C1, this QA observed AB/F JV personnel grinding the weld flush at Y locations 1800, 4300 & 5000.

Magnetic Particle Testing

This QA performed Magnetic Particle Testing (MT) on the following welds:

Weld 12W PP111.1 LS2:

- 230mm of weld back gouge. (100%, MT Accept.)

Weld 12W W2.1-A1 :

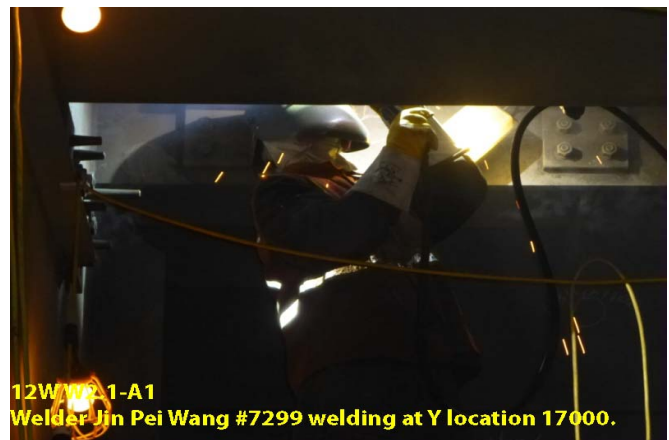
- Y location 17560 in way of indication. (400mm centered on Y location, MT Accept.)

Weld 12W W2.1 116.5-BW2:

- 360mm of weld back gouge. (100%, MT Accept.)

The above welds were previously accepted by QC Magnetic Particle technicians. This QA observed no rejectable indications at the time of testing. This QA Inspector generated a TL-6028 MT report on this date. The completed work observed at this location appeared to be in compliance with the contract specifications.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



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Summary of Conversations:

Conversations relevant to work performed on this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Nina Choy - (510) 385-5910, who represents the Office of Structural Materials for your project.

Inspected By:	Belford,Fritz	Quality Assurance Inspector
Reviewed By:	Levell,Bill	QA Reviewer
